

Date: Wednesday, 3/12/2008 1:41:38 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 37848		
Estimate Number	: 10195		
P.O. Number	:	Part Number	: D21741
This Issue	: 3/12/2008 S.O. No. :	Drawing Number	: D2174-1 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: E
Previous Run	: 31689	Material	:
Written By	:	Due Date	: 3/31/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JA 08 03 12</u>		
Comment	: Est C 04.06.09 Reformat KJ/RF Est Rev:D As per Rev E 06-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick

(M2024T3S.063)

Batch: 106223 IB 8-3-14

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2174

Dwg Rev: EProg Rev: E

IB 8-3-14

(10)

2-Deburr if necessary

IB 8-3-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-3-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/03/15

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

u/l 4 Done at step #22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 08/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:41:38 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 37848

Part Number: D21741

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/02/19 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

21 08-03-23 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

P. 03/03 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P. 03/04 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10 08/03/05

Job Completion



U 08-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	37848
Description: Web		Part Number:	D2174-1
Inspection Dwg: D2174 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

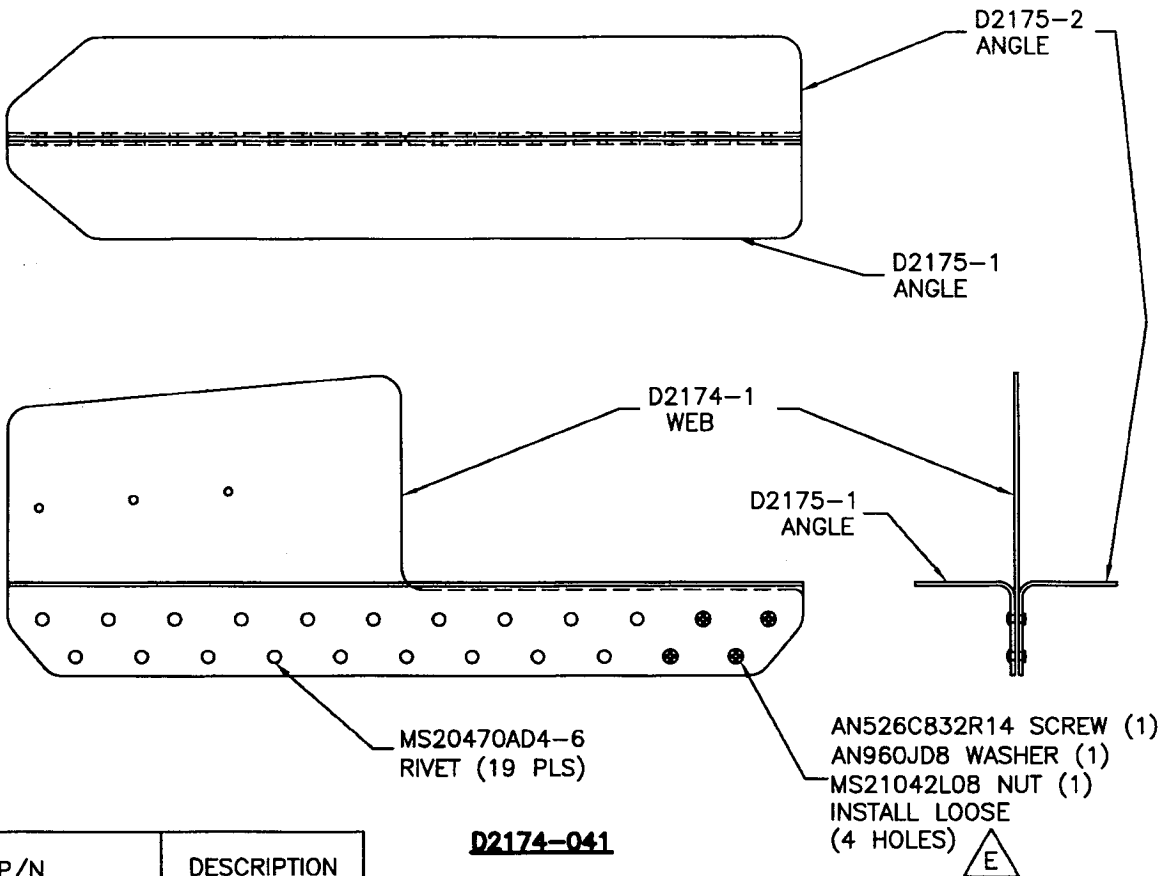
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.247	*			
6.400	+/-0.010	6.400	*			
4.800	+/-0.010	4.801	*			
1.375	+/-0.010	1.374	*			
1.050	+/-0.005	1.050	*			
Ø0.128	+0.005/-0.001	.131	*			
12.650	+/-0.010	12.648	*			
0.550	+/-0.010	.548	*			
0.900	+/-0.010	.900	*			
1.629	+/-0.010	1.628	*			
1.506	+/-0.005	1.504	*			
11.550	+/-0.005	11.550	*			
50°	+/-0.5°	50°	*			
0.063 thick	+/-0.010	.063	*			
Ø0.172	+0.005/-0.001	.176	*			

Measured by:	RB	Audited by:		Prototype Approval:	N/A
Date:	8-3-19	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED CE	DRAWING NO. D2174	REV. E
DATE 06.09.25		TITLE WEB ASSEMBLY	SHEET 1 OF 2
		SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 37848
WORK ORDER

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

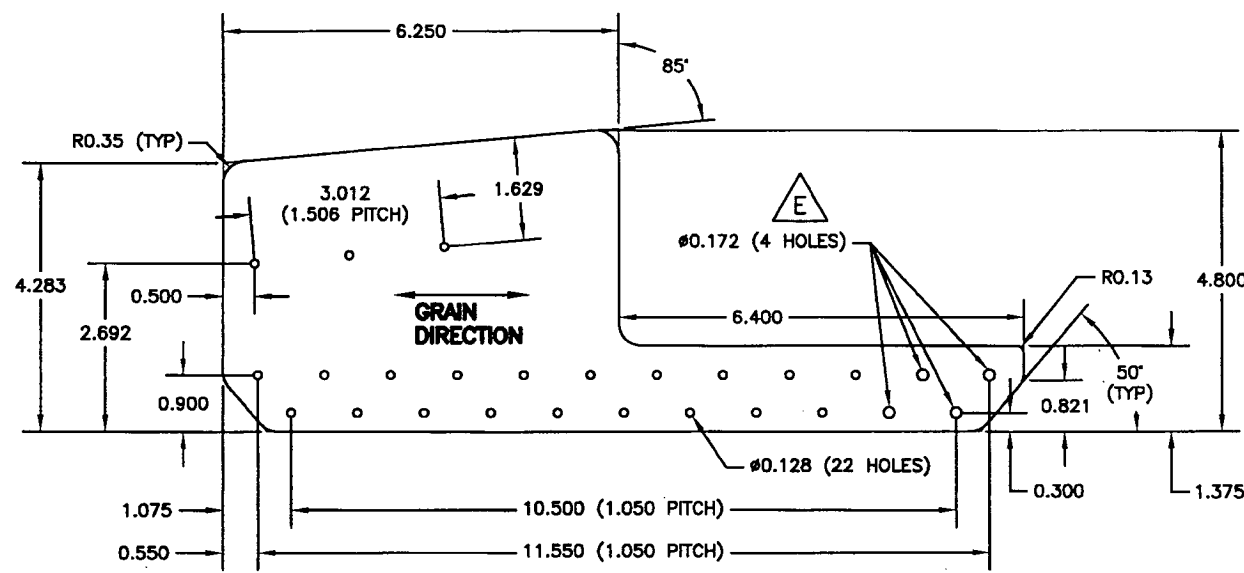
NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13-#



DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD	REV. E
CHECKED	PH	APPROVED	[Signature]	HAWKESBURY, ONTARIO, CANADA	
DATE	06.09.25	TITLE	WEB	DRAWING NO.	SHEET 2 OF 2
				D2174	SCALE
					1:3



D2174-1

- NOTES:
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSION ARE IN INCHES

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NO. 37848

RELEASED
06.10.23

